



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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D5639-2**Job Sheet 200864****Part No:** D5639-2**Job Qty:** 6 pcs**Part Name:** Saddle, Inboard, RH**Part Weight:** 0 lbs**Status:** New**Priority:** Medium**Job Created:** 9/18/19**Job Tracking No:****Due Date:** 10/4/19**Created By:** Marie Lajeunesse**Type:** Stock**Description:****Note:** DWG D5639 REV.A IPP REV.A NEW ISSUE 19/02/06 JFS VERIFIED BY:DD**Ship Via:****Bill of Materials****Job Routing**

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Machining - Issue SN	6 pcs	10/4/19		0.00	0.00	HAAS - 1		SBL 19/11/28
							HAAS - 2		
							HAAS - 3		
							HAAS - 4		
110	HAAS 4 Axis - B4B	6 pcs	10/4/19		3.00	6.67	HAAS - 1 - B4B	DAS	VHS 19/11/30
							HAAS - 2 - B4B	23	
							HAAS - 3 - B4B	9-89	
							HAAS - 4 - B4B		
120	QC 2	6 pcs	10/4/19		0.00	0.00	QC 2 - 1		VHS 19/11/30
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22	DAS	
							QC 2 - 23	23	
							QC 2 - 25	9-89	
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		

**Container No:** S236128**Part:** D5639-2**Job No:** 200864**Serial No/Batch:** S236128**Revision:** A**Inspector:****Exp Date:****Instructions:** Various STC's

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Date: 11/29/19

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130 QC 8	6 pcs	10/4/19	0.00 0.00	QC 2 - 57	
				QC 2 - 62	
				QC 2 - 63	
				QC 2 - 8	
				QC 2 - 66	
				QC 2 - 64	
				QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
				QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
				QC 8 - 57	
				QC 8 - 76	
140 Handfinish - 1-1 Chemical-B4B	6 pcs	10/4/19	0.00 0.75	Handfinish - 1 - 1 - B4B	
				Handfinish - 1 - 2 - B4B	
				Handfinish - 1 - 3 - B4B	
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 - B4B	

MML 12/12/01

DEC 02 2019

					Handfinish - 1 - 17 - B4B	
					Handfinish - 1 - 18 - B4B	
					Handfinish - 1 - 19 - B4B	
					Handfinish - 1 - 20 - B4B	
					Handfinish - 1 - 21 - B4B	
					Handfinish - 1 - 22 - B4B	
150 QC 7	6 pcs	10/4/19	0.00 0.00		QC 7 - 10	
					QC 7 - 13	
					QC 7 - 14	
					QC 7 - 15	
					QC 7 - 17	
					QC 7 - 18	
					QC 7 - 19	
					QC 7 - 2	
					QC 7 - 28	
					QC 7 - 3	
					QC 7 - 30	
					QC 7 - 34	
					QC 7 - 36	
					QC 7 - 37	DAS
					QC 7 - 41	41 DEC 05 2019
					QC 7 - 47	8-89
					QC 7 - 48	
					QC 7 - 51	
					QC 7 - 58	
					QC 7 - 59	
					QC 7 - 60	
					QC 7 - 9	
					QC 7 - 68	
					QC 7 - 50	
					QC 7 - 67	
					QC 7 - 40	
					QC 7 - 24	
					QC 7 - 43	
					QC 7 - 61	
					QC 7 - 81	
					QC 7 - 76	DAS
152 Spray Paint - 2 - B4B	6 pcs	10/4/19	0.00 3.00		Spray Paint - 1 - B4B	41 DEC 05 2019
					Spray Paint - 2 - B4B	8-89
					Spray Paint - 3 - B4B	
					Spray Paint - 4 - B4B	
154 QC 14	6 pcs	10/4/19	0.00 0.00		QC 14 - 15	
					QC 14 - 2	
					QC 14 - 34	
					QC 14 - 41	
					QC 14 - 51	
					QC 14 - 58	
					QC 14 - 59	
					QC 14 - 9	
					QC 14 - 68	
					QC 14 - 40	
					QC 14 - 19	
					QC 14 - 43	
					QC 14 - 24	

				QC 14 - 61	DEC 11 2019
				QC 14 - 81	
160	Packaging 3-1 - Stock - B4B	6 pcs	10/4/19	0.00 0.00	Packaging 3 - 1 - B4B
					Packaging 3 - 2 - B4B
					Packaging 3 - 3 - B4B
					Packaging 3 - 4 - B4B
					Packaging 3 - 5 - B4B
					Packaging 3 - 6 - B4B
					Packaging 3 - 7 - B4B
					Packaging 3 - 8 - B4B
					Packaging 3 - 9 - B4B
					Packaging 3 - 10 - B4B
					Packaging 3 - 11 - B4B
					Packaging 3 - 12 - B4B
					Packaging 3 - 13 - B4B
					Packaging 3 - 14 - B4B
					Packaging 3 - 15 - B4B
					Packaging 3 - 16 - B4B
					Packaging 3 - 17 - B4B
					Packaging 3 - 18 - B4B
					Packaging 3 - 19 - B4B
					Packaging 3 - 20 - B4B
					Packaging 3 - 21 - B4B
					Packaging 3 - 22 - B4B
					Packaging 3 - 23 - B4B
					Packaging 3 - 24 - B4B
					Packaging 3 - 25 - B4B
					Packaging 3 - 26 - B4B
					Packaging 3 - 27 - B4B
					Packaging 3 - 28 - B4B
					Packaging 3 - 29 - B4B
					Packaging 3 - 30 - B4B
					Packaging 3 - 31 - B4B
					Packaging 3 - 32 - B4B
					Packaging 3 - 33 - B4B
					Packaging 3 - 34 - B4B
					Packaging 3 - 35 - B4B
					Packaging 3 - 36 - B4B
170	QC 21 - SA	6 pcs	10/4/19	0.00 0.00	QC 21 - SA - 21
					QC 21 - SA - 70
					QC 21 - SA - 53

Part Op 110 - 1-Machine per folio FC513 DWG REV: A FOLIO REV: A 2- Deburr and break all sharp edges
 Descriptions: 120 - (QC2- Inspect parts off machine FAI/FAIB)
 130 - (QC8- Inspect parts - second check)
 140 - (Chemical Conversion Coat per QSI005 4.1)
 150 - (QC7-Inspect Chemical Conversion Coat)
 152 - PRIME PER DART QSI 005 4.2.1.3.3 (FLOAT SKIDTUBE PRIMER) BATCH: S218188 PAINT GLOSS BLACK
 PER DART QSI 005 4.2.2.4 (FLOAT SKIDTUBE PAINT) BATCH: S210653
 154 - (QC14- Inspect Spray Paint)
 160 - (Identify as per dwg & Stock Location: _____)
 170 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D6101-001	Saddle Billet	6 pcs (1 ea)	100-Machining - Issue SN	<u>S220781</u>

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Machining - Issue SN	D6101-001	6	33	0

Part Specifications

Specifications could not be found.

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DART AEROSPACE LTD				Work Order: 200 864	
Description: SADDLE, INBOARD, RH				Part Number: D5639-2	
Inspection Dwg: A		Rev: A	DSK:	Rev:	Page 1 of 2

FIRST ARTICLE INSPECTION DIMENSION SHEET

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
A	1256	1263		1257	0.257	0.257	0.257	0.257
B	110	130		0.125	0.125	0.125	0.125	0.125
C	R.35	R.410		0.375	0.375	0.375	0.375	0.375
D	110	130		0.1235	0.125	0.125	0.125	0.125
E	1.870	1.880		1.8735	1.874	1.874	1.874	1.874
F	0.635	0.645		0.6395	0.6405	0.6405	0.640	0.639
G	1.395	1.405		1.400	1.400	1.400	1.400	1.400
H	1.943	1.953		1.948	1.948	1.948	1.948	1.948
I	2.328	2.338		2.338	2.338	2.338	2.338	2.338
J	0.040	0.060		0.047	0.053	0.051	0.051	0.051
K	0.241	0.261		0.251	0.250	0.250	0.250	0.250
L	R.1565	1.585		1.575	1.575	1.575	1.575	1.575
M	0.4x45	0.6x45		0.045	0.050	0.050	0.050	0.050
N	1.490	1.510		1.504	0.505	0.505	0.504	0.5045
O	0.675	0.695		0.6845	0.684	0.684	0.684	0.684
P	1.346	1.366		1.361	1.361	1.361	1.361	1.361
Q	R.1125	1.145		1.135	1.135	1.135	1.135	1.135
R	110	130		0.120	0.120	0.119	0.120	0.120
S	113	133		1.126	0.128	0.125	0.125	0.126
T	213	233		0.226	0.227	0.227	0.227	0.2265
U	5.940	6.010		5.998	6.000	6.000	6.000	6.000
V	1.040	1.010		1.003	1.001	1.001	1.001	1.001
W	1.490	1.510		0.496	0.498	0.498	0.498	0.498
X	0.313	0.318		0.313	0.313	0.313	0.313	0.313
Y	1.490	1.510		1.500	0.503	0.503	0.503	0.503
Z	1.245	1.255		1.249	1.250	1.250	1.250	1.250
AA	2.495	2.505		2.499	2.500	2.500	2.500	2.500
AB	110	130		0.120	0.120	0.120	0.120	0.119
AC	115	135		0.1245	0.126	0.126	0.126	0.126
AD	0.265	0.285		0.275	0.275	0.275	0.275	0.275
AE	0.510	0.515		0.510	0.510	0.510	0.510	0.511
AF	0.235	0.240		0.239	0.239	0.239	0.239	0.239
AG								
AH								

Accept/Reject

23
9-89

Measured by: [Signature]	Date: 19/11/30
Audited by: [Signature]	Date: 19/12/01
Preliminary Approval:	Date:

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
B	07.11.08	Reformat	KJ/JLM	
C	12.07.31	Prototype revised to preliminary	KJ	

DART AEROSPACE LTD				Work Order:	
Description:				Part Number:	
Inspection Dwg:	Rev:	DSK:	Rev:	Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				1	2	3	4	5
A	0.256	0.263		0.257				
B	0.110	0.130		0.125				
C	R0.350	R0.410		0.375				
D	0.110	0.130		0.125				
E	1.870	1.880		1.875				
F	0.635	0.645		0.640				
G	1.395	1.405		1.400				
H	1.943	1.953		1.948				
I	2.328	2.338		2.333 2.333				
J	0.040	0.060		0.050				
K	0.241	0.261		0.251				
L	R1.565	R1.585		R1.575				
M	0.04x45°	0.06x45°		0.050x45°				
N	0.490	0.510		0.505				
O	0.675	0.695		0.685				
P	1.346	1.366		1.356				
Q	R1.125	R1.145		R1.135				
R	0.110	0.130		0.120				
S	0.113	0.123		0.1265				
T	0.213	0.233		0.226				
U	5.990	6.010		6.000				
V	0.990	1.010		1.000				
W	0.490	0.510		0.503				
X	0.313	0.318		0.313				
Y	0.490	0.510		0.501				
Z	1.245	1.255		1.250				
AA	2.495	2.505		2.500				
AB	0.110	0.130		0.120				
AC	0.115	0.135		0.126				
AD	0.263	0.283		0.275				
AE	0.510	0.515		0.510				
AF	0.233	0.240		0.239				
AG								
AH								

Accept/Reject **DAS**
23
9-89

Measured by: <i>VHS</i>	Date: <i>19/11/30</i>
Audited by: <i>mm</i>	Date: <i>19/12/01</i>
Preliminary Approval:	Date:

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
B	07.11.08	Reformat	KJ/JLM	
C	12.07.31	Prototype revised to preliminary	KJ	